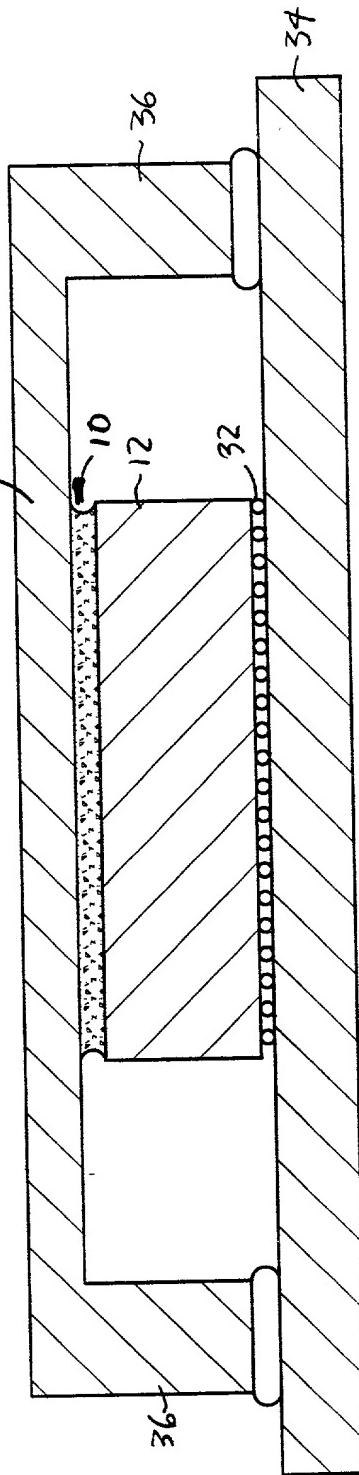
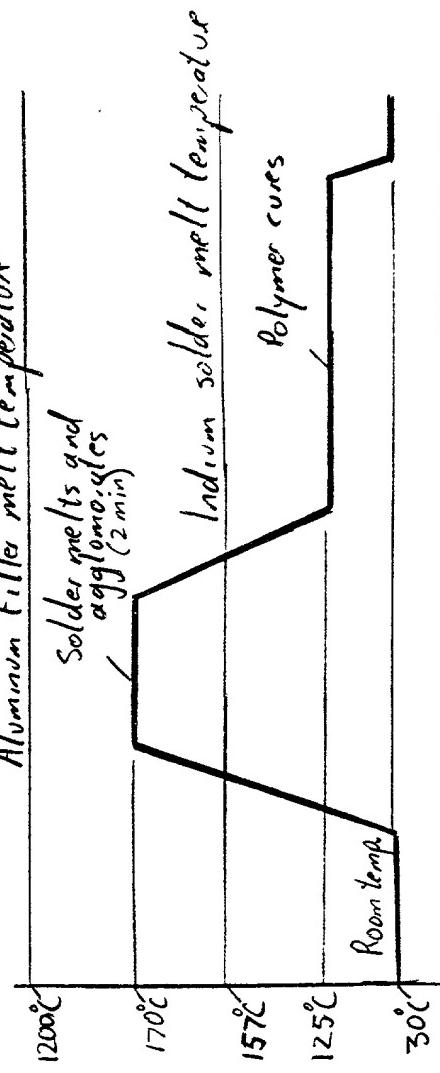


30

FIG 3



Aluminum Filler melt temperature



Time

FIG 4